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		Dart Aerospace Ltd. 1270 Aberdeen St Hawkesbury, ON K6A 1K7 Canada Tel (613) 632-5200		RB877406-5-2 Job Sheet 176993 				
Part No: RB877406-5-2 Job Qty: 1 ea Part Name: Bearing Cutter Tool Assembly 		Status: At Planning Priority: High Part Weight: 0 lbs Job Created: 5/4/18 Job Tracking No: Due Date: 6/4/18 Created By: Marie Lajeunesse Type: SOLD Description: Note: DWG RB877406-5 Rev. 1A IPP Rev. A 18.04.20 new issue DP Verify DD Ship Via:						
Bill of Materials								
Job Routing								
Op No	Operation	Qty	Start Date	Due Date	Standard Setup hrs Run hrs	Workcenter/Supplier	Lead Time	Sign-off
90	Start up Operation	1 Ea	6/4/18	6/4/18	0.00 0.00	Start Up Small Fab-4		ML
100	Small Fab	1 pcs	6/4/18	6/4/18	0.08 0.17	Small Fab-9		ML DAS
110	QC	1 pcs	6/4/18	6/4/18	0.00 0.00	QC5		38
130	Packaging	1 pcs	6/4/18	6/4/18	0.00 0.00	Packaging3-2		SP18-89-3 GA/40
140	QC21-SA	1 Ea	6/4/18	6/4/18	0.00 0.00	QC21		
Part Op 100 - Assemble as per DWG. Descriptions: 130 - IDENTIFY AND STOCK						DAG 21 9-00 JUL 04 2018		
Job BOM								
Part / Item	Component Name	Quantity	Operation	Container				
9657K122	Ø0.437 OD x Ø0.054 WIRE x 2, 15.54 LBS/IN. SPRING	1 Ea (1 ea)	90-Start up Operation	FM 138414-31				
DK-55	Knob	1 Ea (1 ea)	90-Start up Operation	5051749				
NTA-512	Bearing	1 Ea (1 ea)	90-Start up Operation	5057540				
RB877406-5-1	Shaft	1 Ea (1 ea)	90-Start up Operation	5060994				
RB877406-5-3	Handle	1 Ea (1 ea)	90-Start up Operation	5079325				
RB877406-5-7	Cutter	1 Ea (1 ea)	90-Start up Operation	5078026				
TRA-512	Washer	2 Ea (2 ea)	90-Start up Operation	5029022				
Job Allocations								
Operation	Component Part	Required	Inventory	Allocated				
90-Start up Operation	9657K122	1	22	0				
	DK-55	1	6	0				
	NTA-512	1	20	0				
	RB877406-5-1	1	0	0				
	RB877406-5-3	1	0	0				
	RB877406-5-7	1	0	0				
	TRA-512	2	30	0				
Part Specifications								
Specifications could not be found.								

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Container No: S085014



Part: RB877406-5-2

Job No: 176993

Serial No/Batch: S085014

Revision: 1A

Inspector:

Exp Date:

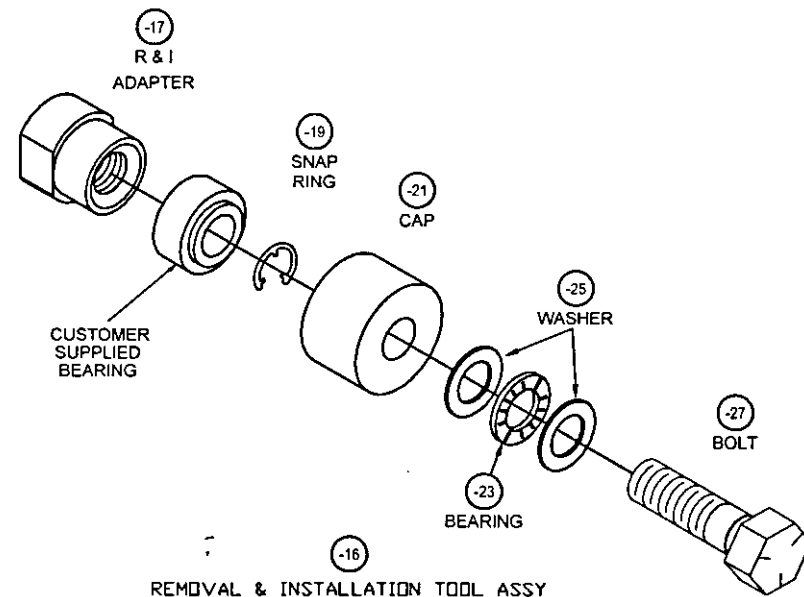
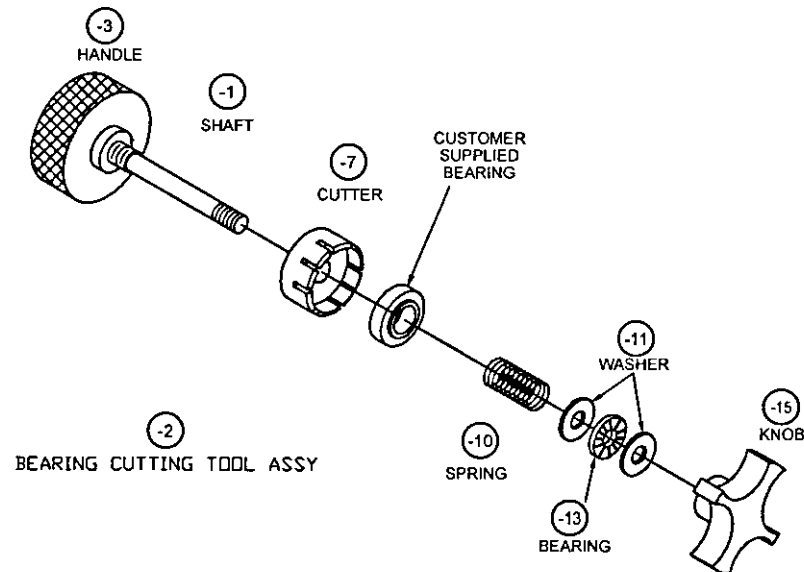
Instructions:

Dart Aerospace Ltd.
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Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/27/18

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL / APPROVED
1	-7 RADIAL ANGLE INCREASED FROM 2" TO 5" TO IMPROVE OPERATION.	2/19/04	
1A	CH'D TITLEBLOCK & REVISION BLOCK, CH'D REVISIONS TO NUMERICAL, CORRECTED VIEWS & LABELED ALL SECTION VIEWS, ADDED DETAIL A P/N -1 TO CLARIFY TAPER.	9/30/09	RJC RW



ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS	Pg.
	1		-1		SHAFT	STRESS PROOF	Ø3/4 x 4	2
	1		-2	1	BEARING CUTTER TOOL ASSY			1
	1		-3		HANDLE	6061 T6	Ø2 x 3/4	2
	1		-7		CUTTER	01	Ø1-1/16 x 3/4	3
	1	B/O	-10		SPRING	-	5/16 x 2 (EUGENE FASTNER #16)	1
	2	B/O	-11		WASHER	-	TRA-512 (APPLIED INDUSTRIAL)	1
	1	B/O	-13		BEARING	-	NTA512 (APPLIED INDUSTRIAL)	1
	1	B/O	-15		KNOB	-	DK-55 (REID TOOL)	1
	1		-16	1	REMOVAL & INSTALLATION TOOL ASSY			1
	1		-17		R&I ADAPTER	STRESS PROOF	Ø1-1/4 x 1-1/4	4
	1	B/O	-19		SNAP RING	-	Ø5/16 EXTERNAL	1
	1		-21		CAP	6061 T6	Ø1-1/2 x 1	4
	1	B/O	-23		BEARING	-	NTA512 (APPLIED INDUSTRIAL)	1
	2	B/O	-25		WASHER	-	TRA-512 (APPLIED INDUSTRIAL)	1
	1		-27		BOLT	GRADE 5	5/16-24 UNF x 3 MODIFY	4
ASSY QTY	ASSY QTY							
-16	-2							

RED BARN MACHINE	
TITLE DAMPER BEARING CUTTING TOOL	
DWG NO. RB877406-5	REV 1A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 X ± .1	
FRACTIONS ± 1/32 ANGLES ± 5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 6-28-01
SHEET 1 of 4	
DRAWN BY COLE	APPROVED
HEAT TREAT	FINISH SPEC
USED ON MODEL BELL 406	